

Sup 06/01

Work Order ID 64922

January 3, 2011 10:36:32 AM

Page 1

Item ID: D4310-1

Accept

Revision ID:

Item Name: Block

Start Date: 1/06/11

Start Qty: 10.00

Required Date: 1/06/11

Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4310

A

100

0.00



HAAS I

HAAS CNC vertical machine #1

Memo

MACHINE AS PER FOLI FB027 AND DWG

FOLIO REV: AA

DWG REV: A

DEBURR

0.00

and 10/01/06

10 5

(PTU)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00


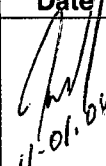


and 10/01/06

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 10-01-06

Resolution: _____ Disposition: _____ QA: N/C Closed: ☒ Date: 11/01/11

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/05	100	Sparks scrapp. some dim. are off. Prod ERROR. Test for best finish.		update program scrap? destroy. replace	 11-01-06	M.A 11/01/06		 10-01-06
		R.L. program error! New program						

NOTE: Date & initial all entries

Work Order ID 64922

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Item ID: D4310-1

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Start Date: 1/06/11

Start Qty: 10.00

Required Date: 1/06/11

Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC 8 inspection
- Second check
Memo

0.00

0.00

B.A 11/01/06

10

0

130



Packaging

Packaging

Identify as per dwg & Stock Location: SHIP 0.00

Memo

P-3836

0.00

11/01/06 10

140



QC

Quality Control

QC21- Final Inspection - Work Order Release 0.00

Memo

0.00

CK 11/01/06

11/01/06

Picklist Print

Page 1

January 3, 2011 10:36:30 AM

Work Order ID: 64922



Parent Item: D4310-1



Parent Item Name: Block


Start Date: 1/06/11

Required Date: 1/06/11

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 11.01.03 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MPTFES2.000  Polytetrafluoroethylene Molded Sheet		Purchased	No			100	f	0.0000	0.1666	1.753684			

M116533 1.753 2/11/01/05

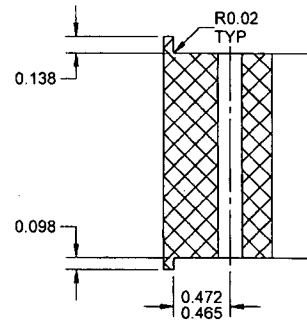
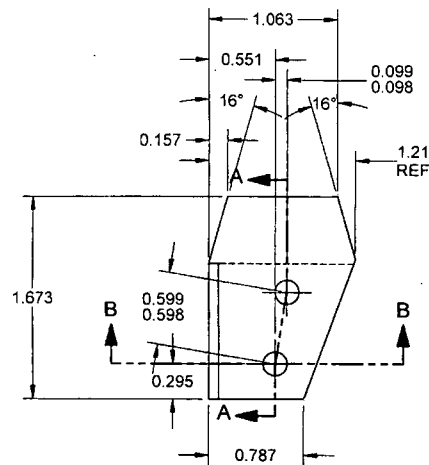
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

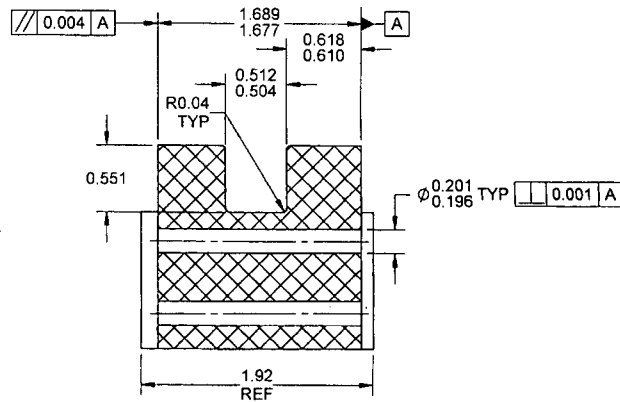
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

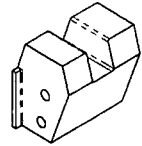
NOTE: Date & initial all entries



SECTION B-B



SECTION A-A



D4310-1 BLOCK, ANTI-ROTATION

- NOTES:**
- 1) MATERIAL: PTFE SHEET, 2.00 THICK X 2.00 WIDE
PER AMS3667
REF DART SPEC MPTFES
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.020 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.21 lbs

A NEW ISSUE		10.12.16	
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4310	REV. A
TITLE BLOCK, ANTI-ROTATION	SCALE NTS

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RELEASED
2010-12-21
PER ECN 10-673

DART AEROSPACE LTD		Work Order: 64922
Description: BLOCK, ANTI-ROTATION		Part Number: D4310-1
Inspection Dwg: D4310 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.673	$\pm .010$	1.675	—		Vern	ML-7
.598	$\pm .006$.598	—		"	"
.295	$\pm .010$.297	—		"	"
.787	$\pm .010$.786	—		"	"
1.21	$\pm .030$	1.212	—		"	"
.098	$\pm .001$.098	—		High-gage	31006
1.063	$\pm .010$	1.060	—		Vern	ML-7
.551	$\pm .010$.552	—		"	"
16°	$\pm 1/2^\circ$	16°	—		Cont square	ML-CBB
.138	$\pm .010$.141	—		Vern	ML-7
.098	$\pm .010$.102	—		"	"
.465	$\pm .007$.467	—		High-gage	31006
.551	$\pm .010$.550	—		Vern	ML-7
1.92	$\pm .030$	1.927	—		"	"
Ø.196	$\pm .005$	Ø.197	—		"	"
.610	$\pm .008$.615	—		"	"
.504	$\pm .008$.508	—		"	"
1.677	$\pm .012$	1.685	—		"	"
R.04	$\pm .030$	R.040	—		Rad-gage	REF

Measured by: <i>mf</i>	Audited by: <i>M.A</i>	Prototype Approval:	N/A
Date: 11/01/06	Date: 11/01/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	